

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018189**Date Inspected:** 15-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD (11BW-11CW)**

This QA Inspector along with QA Inspector Mr. Manjunath S Math performed dimensional joint survey inspection after adjustments on the B4 work point across transverse splice joints to verify the skin flatness using 5 meter string line, 600mm and 630mm straight edge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11BW to Segment 11CW - PP 100 to PP 101

**OBG # TRIAL ASSEMBLY YARD (12AW)**

This QA Inspector along with QA Inspector Mr. Manjunath S Math performed dimensional joint survey inspection after heat straightening on the floor beam to verify the flatness using 1500mm straight edge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 12AW – PP 111

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### OBG # TRIAL ASSEMBLY YARD (11CW-11DW)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the WT stiffeners to verify the horizontal and vertical offset using 1000mm straight edge and bridge cam gauge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11CW to Segment 11DW – PP 103 to PP 104

### OBG # TRIAL ASSEMBLY YARD (11BW-11CW)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the longitudinal diaphragm to verify the offset using 1000mm straight edge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11BW to Segment 11CW – PP 100 to PP 101

This QA Inspector randomly observed the following work in progress:

### OBG # TRIAL ASSEMBLY YARD (11DE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 012 in the (4F) overhead position on edge panel 'I' stiffener piece mark no. EP173-001. The location was the hold back of WT stiffener fillet weld of segment 11DE. The welder ID was 050289. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

### OBG # TRIAL ASSEMBLY YARD (11EE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 006 in the (4F) overhead position on edge panel 'I' stiffener piece mark no. EP174-001. The location was the hold back of WT stiffener fillet weld of segment 11EE. The welder ID was 050289. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

### OBG # TRIAL ASSEMBLY YARD (11EE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on longitudinal diaphragm piece mark no. SEG074B. The location was the complete joint penetration groove weld joining the flange of longitudinal diaphragm to floor beam of PP 107- segment 11EE at work point E4. The welder ID was 040484. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

For additional information please reference the pictures below:

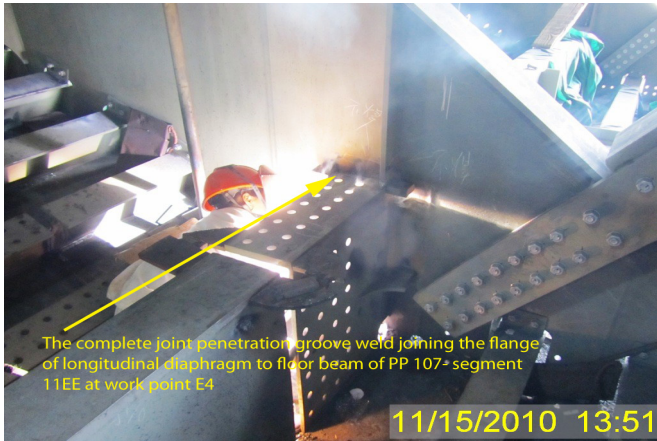
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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Manikandan,Murugan
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art
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QA Reviewer
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